

Institute For Auto Parts and Hand Tools Technology, Ludhiana

Rate List of Institute Services (w.e.f 15/05/2022)

S. No.	Job Description	Charges (Rs.)	Remarks
Heat Treatment Services			
1.	Annealing, Normalizing and Tempering. M.S. Alloy Steel and other constructional / steels and sheet metal components.	9.20	Per Kg
2.	Carburizing and Air Cooling of M.S. & Alloy Steels		
	0.3 – 0.6mm C.D. Oil Quenching	21.85	Per Kg
	0.7 – 0.9mm C.D. Oil Quenching	24.15	Per Kg
	0.9 – 1.2mm C.D. Oil Quenching	26.50	Per Kg
3.	Hardening & tempering up to 300 mm length		
	Up to Φ 12mm x 300mm length max. (in Rotary Furnace only)	11.50	Per Kg
	Up to Φ 12mm – 20 mm x 300mm length max.	15.00	Per Kg
	Up to Φ 12mm x (300 - 800 mm) length	16.10	Per Kg
	Up to Φ 20mm - 50mm x (300 – 800mm) length	18.40	Per Kg
4.	Hardening & Tempering of material (medium alloy steel)	18.40	Per Kg
5.	Hardening & Tempering of hand tools (Spanners, Wheel Spanners)	16.10	Per Kg
6.	Hardening and Tempering of long sheets and blades / extra-long jobs.	34.50	Per Kg
7.	Hardening & Tempering of High Carbon, High Chromium Dies, D3, EN-31, Tools and Gauges etc.	80.50	Per Kg
8.	Cryogenic Material Improvement Process	184	Per Kg
9.	Hardening & tempering in Continuous Furnace; Make San Yung Taiwan Plant (up to ϕ 20 x 250 mm with the assumption 300 kg / hr.)	16.10	Per Kg • Note: Extra Charges for complex configuration (shape & size). • Lot Min. charges Rs 12,000/- (Rs. Twelve thousand only).

Note:

1. Above Heat Treatment Rates are based on the assumption for a batch lot of 300 kg. in GCF.
2. In case of hardening to be done in carbon potential then Rs. 2/- will be charged extra over and above on the above-mentioned rates.
3. Complex configuration to be determined on the basis of shape, size, mass & material composition and shall be used for any extra charges of Heat Treatment.
4. Minimum billing charges for Heat Treatment process is Rs 300/- only (Rupees Three hundred only).
5. The customer who provides material lot of 20000 kg will be provided discount of rate for the material Hardening & tempering in Continuous Furnace; Make San Yung, Taiwan Plant.
6. Taxes as applicable.

